

23

Date: Wednesday, 5/16/2007 1:28:15 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG EXTRUSION  
 Job Number : 32387  
 Estimate Number : 10326  
 P.O. Number : *N/A* Part Number : D27317 *ul*  
 This Issue : 5/16/2007 S.O. No. : *N/A* Drawing Number : D2731 REV B  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : *N/A* Type : MACHINED PARTS Drawing Revision : B  
 Previous Run : 30995 Material : *N/A*  
 Written By : Due Date : 6/6/2007 Qty: 64 Um: Each  
 Checked & Approved By : *07.05.16*  
 Comment : Est D 06.05.19 Added inspect level 8, removed P/O powder coating EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2423 Lug Extrusion



Comment: Qty.: 0.0717 f(s)/Unit Total: 4.5898 f(s)

Lug Extrusion D2423

Batch: *30062*

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut D2423 extrusion to .82"

Batch: \_\_\_\_\_

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



*PG*

*Issue P/O 3812*



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per folio D2731-7.

2-Check for crack while loading into the machine.

3-Tumble

4-Deburr any rough edges after tumbling

*machine per drawing  
D2731 REV. B*

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



*RG*

*Received +  
inspect  
for thickness damage*



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC5 SECOND CHECK



Comment: SECOND CHECK

*inspect level 5*

*06-06*

*counted 64*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: 2 Date: 07/07/06

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 1:28:15 PM  
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## Process Sheet

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Drawing Name: LUG EXTRUSION

Job Number: 32387

Part Number: D27317

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MS

07-06-06

counted

(64)

7.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

-PRIME

-PAINT DELFLEET BLUE (PER QSI005)

-CLEAR DELFLEET

8.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

57433

stock unpainted

07/15

(64)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/15/06

(64)

Job Completion



in 07-07-06

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

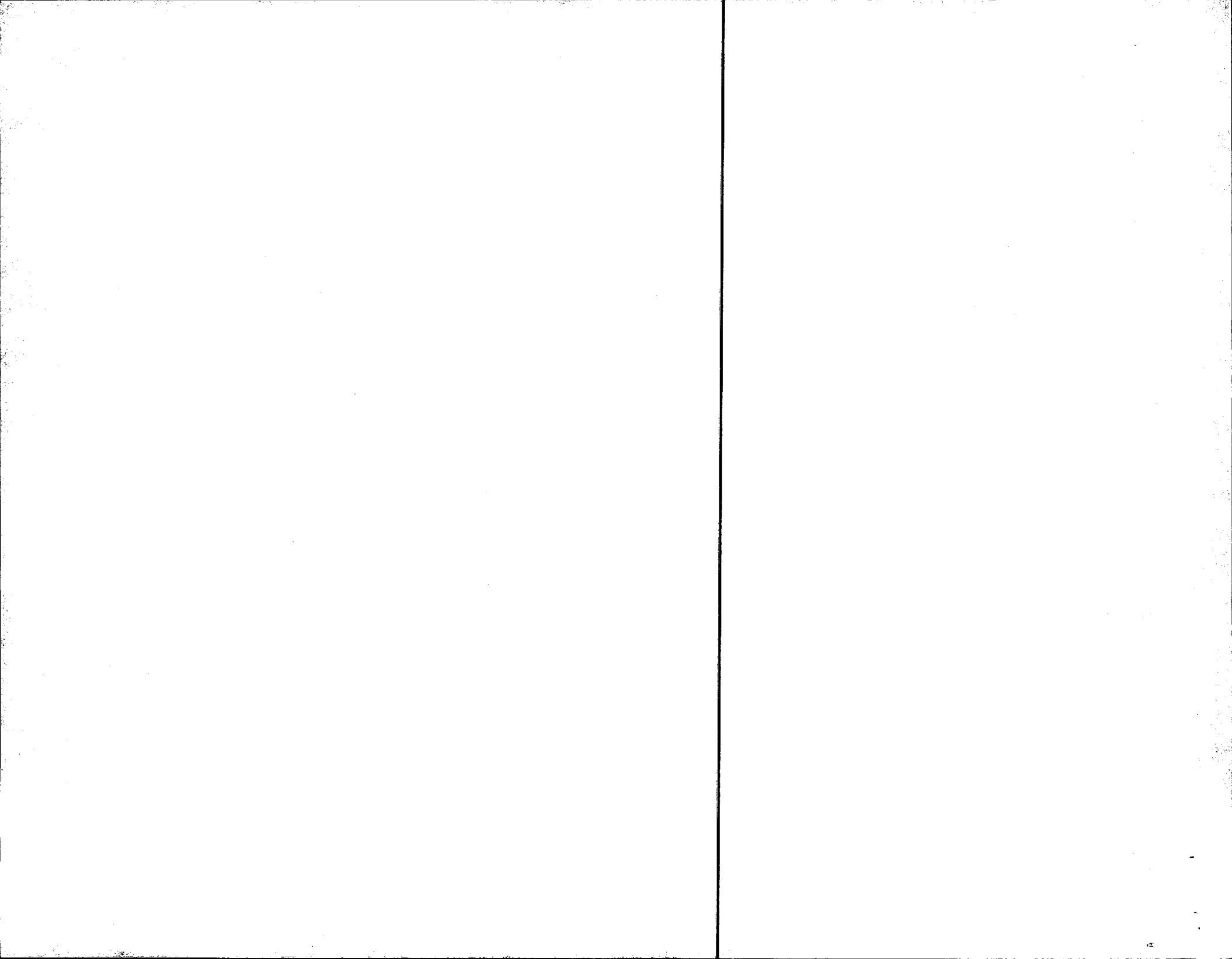
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
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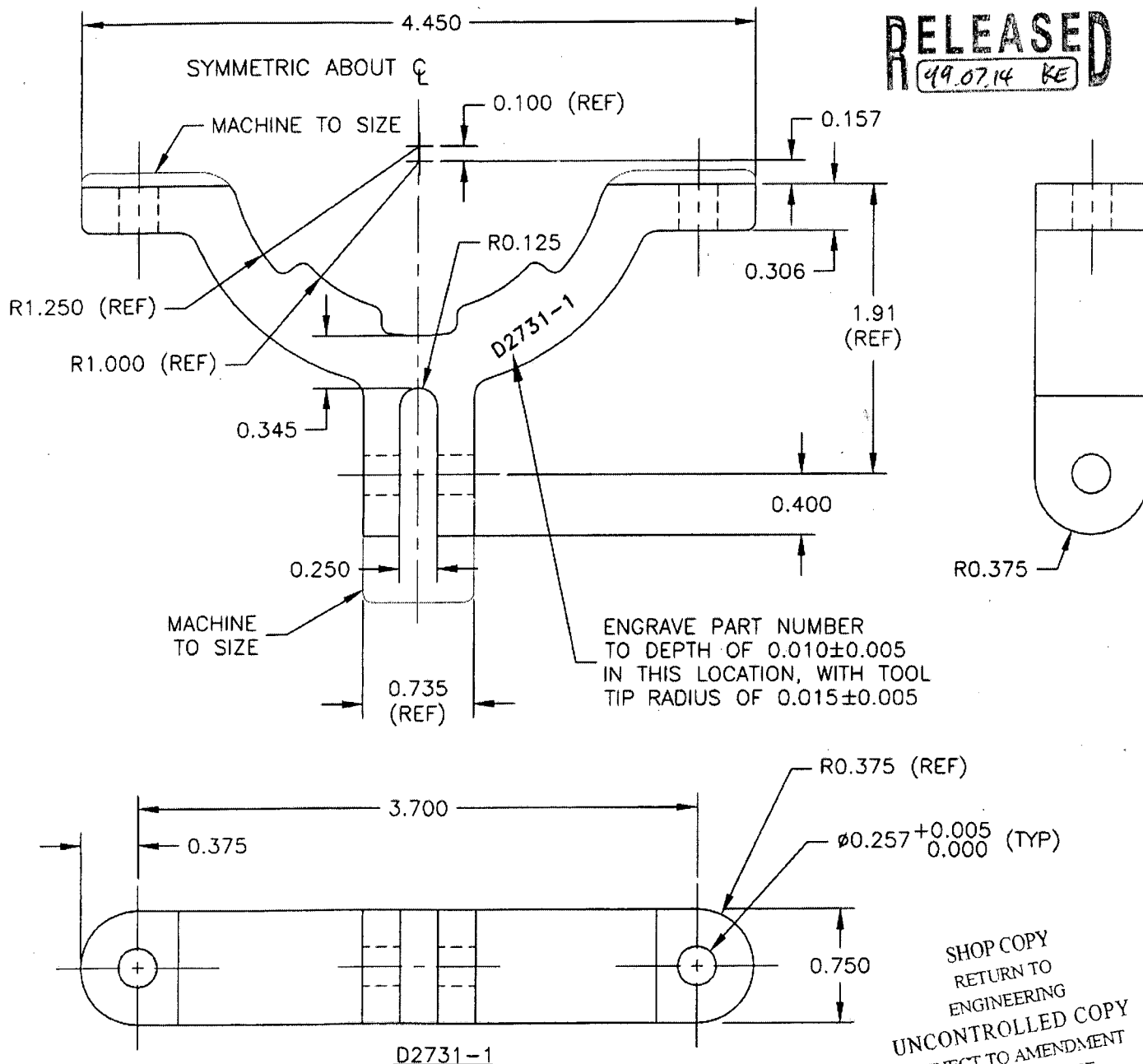
**NOTE:** Date & initial all entries







DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2731	REV. B SHEET 1 OF 4
DATE 99.07.06	TITLE MOUNTING LUG		SCALE 1:1
A	98.05.13	NEW ISSUE	
B	99.07.06	REVISED DIMENSIONS	



RELEASED  
99.07.14 KE

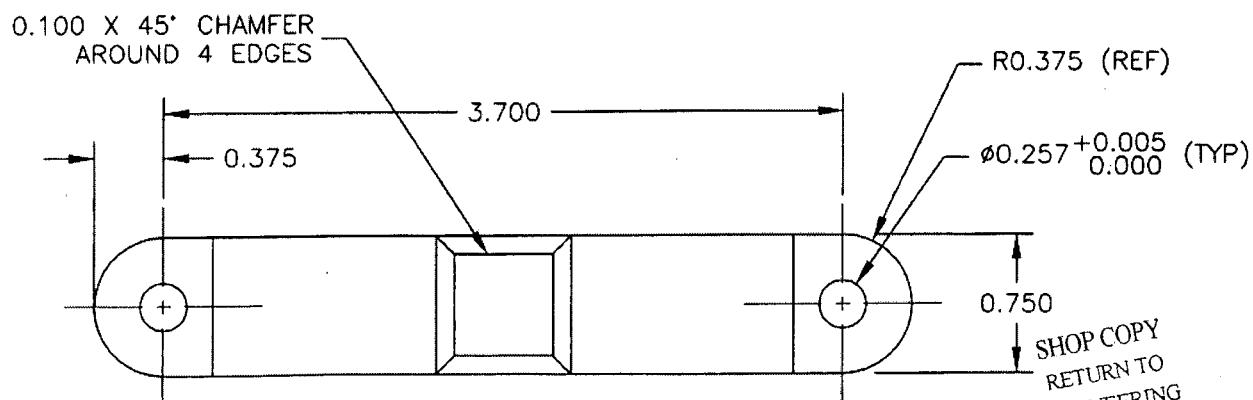
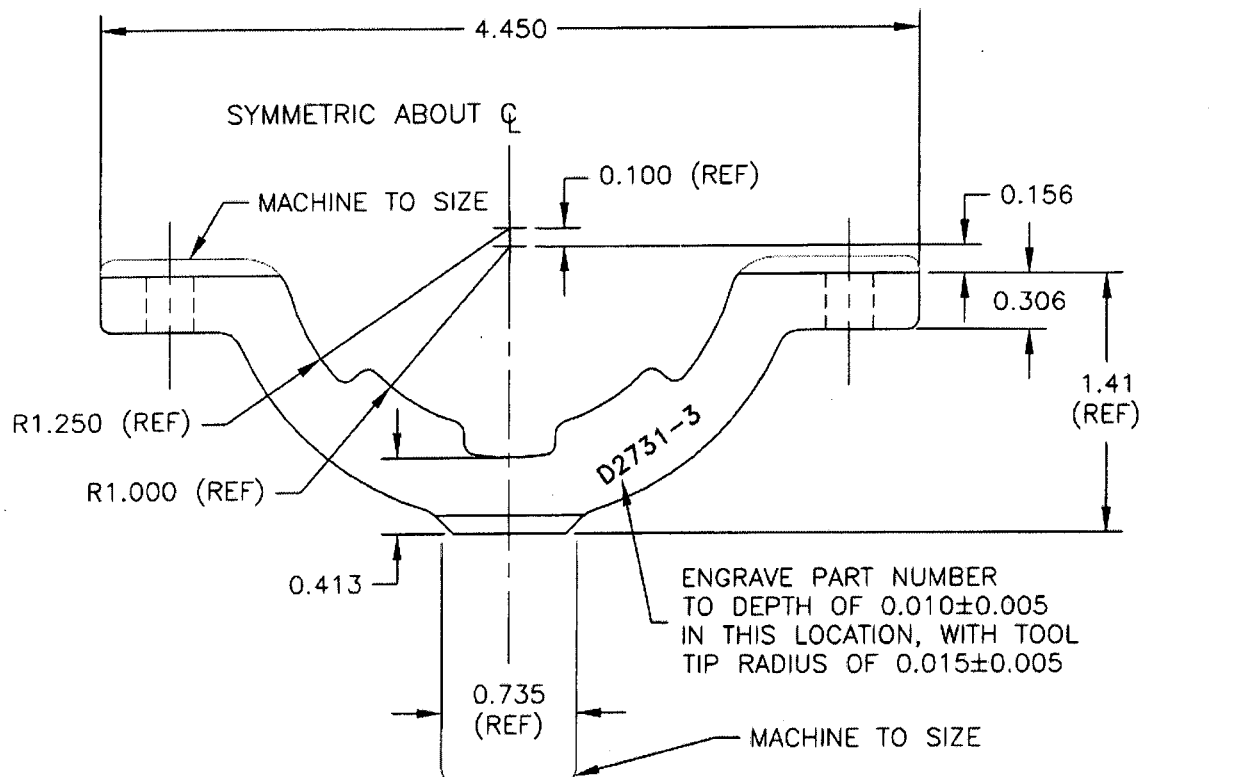
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 32387

MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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CHECKED <i>KE</i>	APPROVED <i>QJ</i>	DRAWING NO. D2731	REV. B SHEET 2 OF 4
DATE 99.07.06		TITLE MOUNTING LUG	SCALE 1:1

RELEASED  
99.07.14 *KE*



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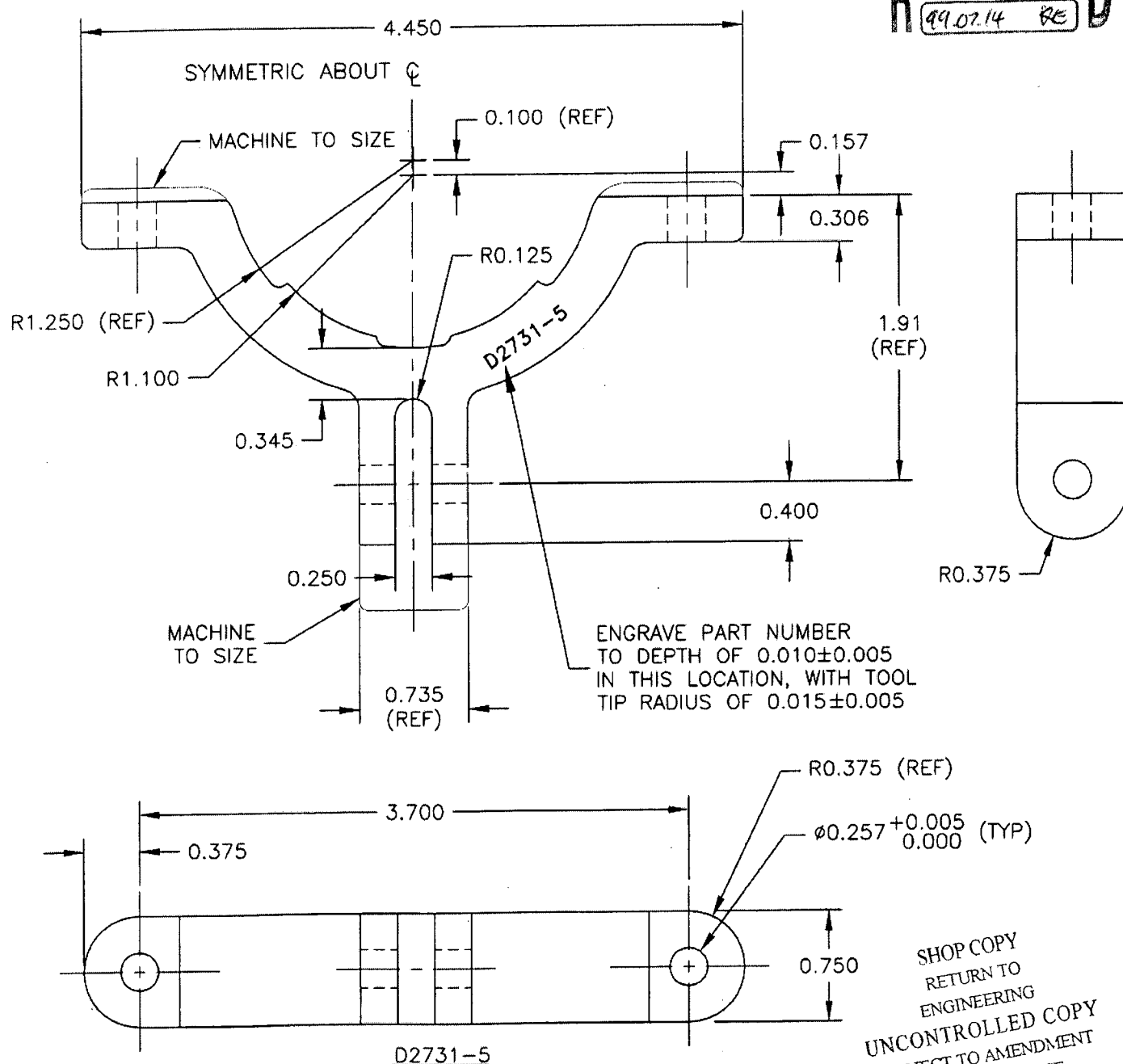
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DATE 99.07.06	TITLE MOUNTING LUG		SCALE 1:1

RELEASED  
99.07.14 RE



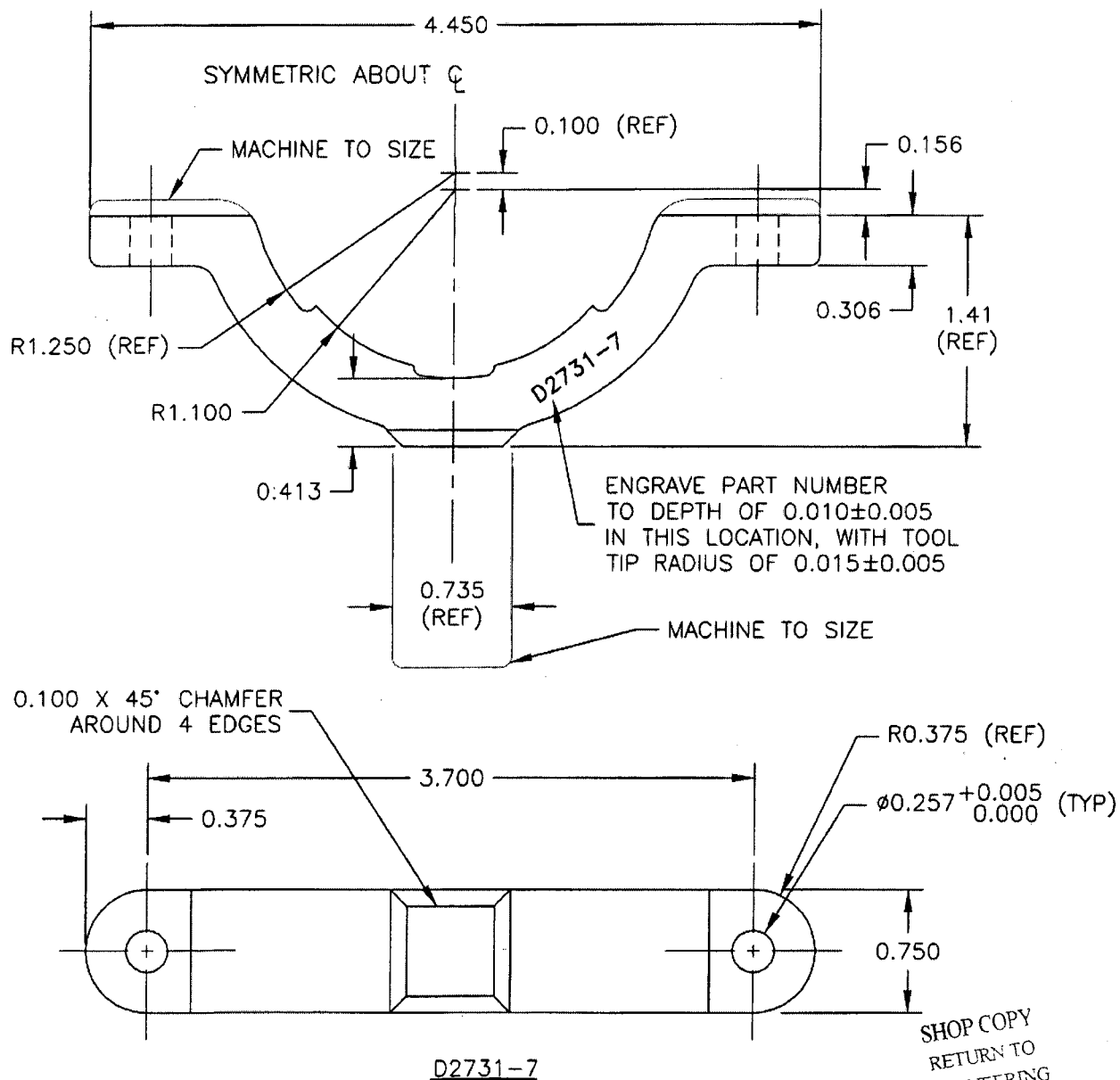
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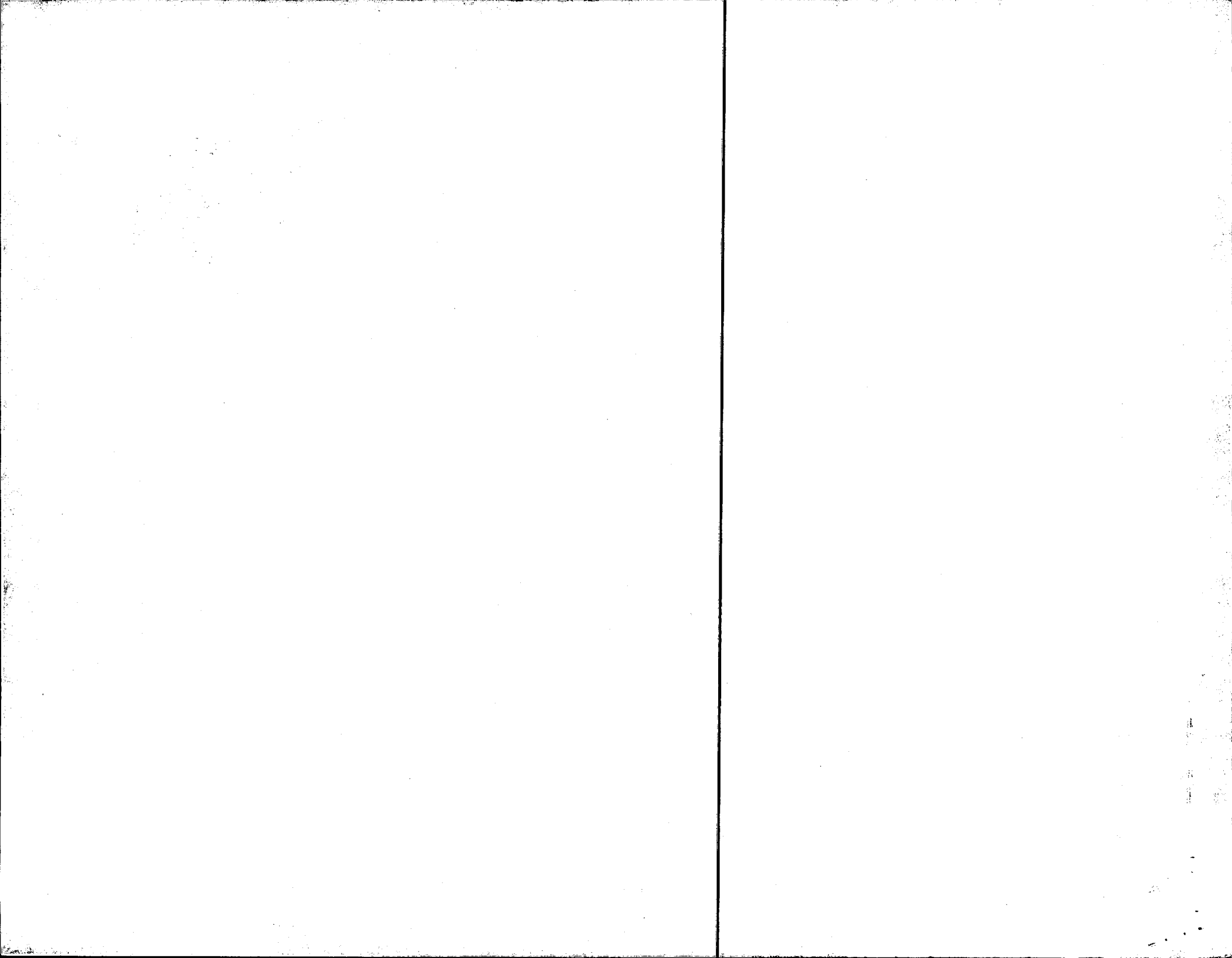
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CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2731	REV. B SHEET 4 OF 4
DATE 99.07.06	TITLE MOUNTING LUG		SCALE 1:1

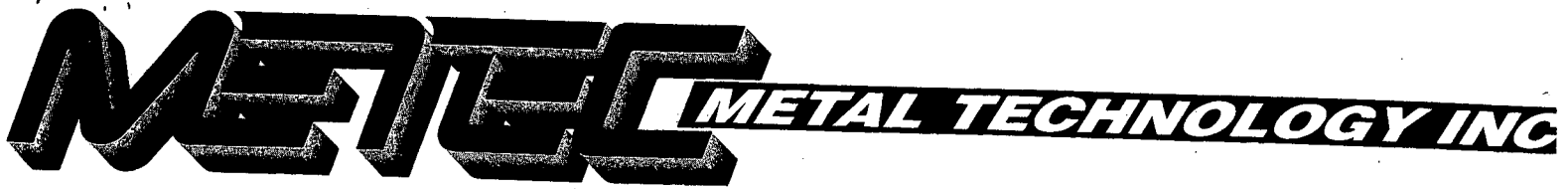
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99.07.14 *KE*



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## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

64

D2731-7

Lug B32387

3812

64

D2731-7

Lug B32388

3812

MATERIAL: supplied by DART D2423 B30062

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

  
Shigi (Regula) Walz

Vankleek Hill, June 1, 2007



20 Terry Fox Drive  
Vankleek Hill, Ontario K0B 1R0  
Tel: (613) 678-3957  
Fax: (613) 678-3956

Delivery Slip No.: **15909**  
Date: Jun 01, 2007  
Page: 1

<b>Sold to:</b>  <b>Dart Aerospace Ltd.</b> Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	<b>Ship to:</b>  Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
<b>Order No.:</b> 3812	<b>Sold By:</b> Walz, Christian D.
<b>Shipped By:</b> our truck	<b>Ship Date:</b>

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-1 Mounting Lug B32163	Each	370		370
D2731-7 LUG B32387	Each	64 ✓	64	
D2731-7 LUG B32388	Each	64 ✓	64	
Cut from D2423 B30062 extrusion				
Received by _____		Thank you for your order!		